



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5610-1TRN
Job Sheet 191954


Part No: D5610-1TRN	Job Qty: 1 pcs
Part Name: EC130 Aft Crosstube Turning Detail	
	
Part Weight: 0 lbs	Status: Scheduled
Job Created: 3/13/19	Job Tracking No:
Due Date: 4/12/19	Created By: Linda Lacelle
Type: Stock	Description:
Note: D5610 REV.B IPP REV:A 18.07.04 NEW ISSUE DD VERF:JFS	
Ship Via:	

Bill of Materials

P.T.O.

SCRAP

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		4/12/19	0.00	0.00	Start Up Crosstubes-1	
95	Mori Seiki TL-40 - 1 - B4B	1 pcs		4/12/19	0.00	2.00	Mori Seiki TL-40 - 1 - B4B	
100	Mori Seiki TL-40 - 1	1 pcs		4/12/19	4.40	2.38	Mori Seiki TL-40	
110	QC 2	1 pcs		4/12/19	0.00	0.00	QC2-1	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs		4/12/19	0.00	2.38	Mori Seiki TL-40 - 1 - B4B	
130	QC 2	1 pcs		4/12/19	0.00	0.00	QC 2 - 66	
140	QC 8	1 pcs		4/12/19	0.00	0.00	QC8	
145	Crosstubes - 4 - B4B	1 pcs		4/12/19	0.00	0.68	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
146	Outsource - 2 - NDT per QSI038	1 pcs		4/12/19			SKY002-VC	
147	Packaging 2-1 - Receive - B4B	1 pcs		4/12/19	0.00	0.00	Packaging 2 - 5 - B4B	
148	QC 6	1 pcs		4/12/19	0.00	0.00	QC 6 - 40	
150	Crosstubes - 5 - B4B	1 pcs		4/12/19	0.00	1.00	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
160	QC 7	1 pcs		4/12/19	0.00	0.00	QC7-1	
170	Packaging 3-1 - Stock - B4B	1 pcs		4/12/19	0.00	0.00	Packaging3-1	
180	QC 21 - SA	1 pcs		4/12/19	0.00	0.00	QC21	

See attached work order

JUN 07 2019

Part Op 100 - 1- Fill tube with sand & install plugs 2- Face and chamfer both ends as per Folio FC197 3- Turn first taper section on

Descriptions: both side

120 - 1- Turn second taper on both side 2- Scribe part # and batch # using vibrating stylus on INSIDE the cuff as per Dwg D5610-TRN

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

146 - ISSUE P/O:

150 - 1- handfinish X-TUBE INSIDE AND OUT

160 - ***IDENTIFY SERIAL/ P/N # BY USING A MARKER IN THE MIDDLE OF TUBE AT CONTAINER CREATION***

INSPECT ALODINE AND MAKE SURE TUBE IS IDENTIFY WITH MARKER IN THE MIDDLE OF THE TUBE

170 - ***IDENTIFY SERIAL # BY USING A MARKER IN THE MIDDLE OF TUBE AT CONTAINER CREATION***

INSPECT ALODINE AND MAKE SURE TUBE IS IDENTIFY WITH MARKER IN THE MIDDLE OF THE TUBE

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6030-140	Tube, Seamless	1 pcs (1 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6030-140	1	0	0

Part Specifications				
Specifications could not be found.				



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3

D5610-1TRN
Job Sheet 191954



Part No: D5610-1TRN

Job Qty: 1 ea

Part Name: EC130 Aft Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/13/19

Job Tracking No:

Due Date: 4/12/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: D5610 REV.B IPP REV:A 18.07.04 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/12/19	4/12/19	0.00	0.00	Start Up Crosstubes-1		2019-03-26
100	Mori Seiki	1 pcs	4/12/19	4/12/19	4.40	2.38	Mori Seiki TL-40		2019-03-29
110	QC	1 pcs	4/12/19	4/12/19	0.00	0.00	QC2-1		67
120	Mori Seiki	1 pcs	4/12/19	4/12/19	0.00	2.38	Mori Seiki TL-40		19-04-01
130	QC	1 pcs	4/12/19	4/12/19	0.00	0.00	QC2-1		
140	QC	1 pcs	4/12/19	4/12/19	0.00	0.00	QC8		
145	Crosstubes	1 pcs	4/12/19	4/12/19	0.00	0.68	Crosstubes-1		
150	HandFXtube	1 pcs	4/12/19	4/12/19	0.00	1.00	Crosstubes-3		
160	QC	1 pcs	4/12/19	4/12/19	0.00	0.00	QC7-1		
170	Packaging	1 pcs	4/12/19	4/12/19	0.00	0.00	Packaging3-1		
180	QC21-SA	1 Ea	4/12/19	4/12/19	0.00	0.00	QC21		

Part Op 100 - 1- Fill tube with sand & install plugs 2- Face and chamfer both ends as per Folio FC197 3- Turn first taper section on Descriptions: both side

120 - 1- Turn second taper on both side 2- Scribe part # and batch # using vibrating stylus on the cuff as per Dwg D5610-TRN

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6030-140	Tube, Seamless	1 pcs (1 ea)	90-Start up Operation	5078768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6030-140	1	5	0

Part Specifications

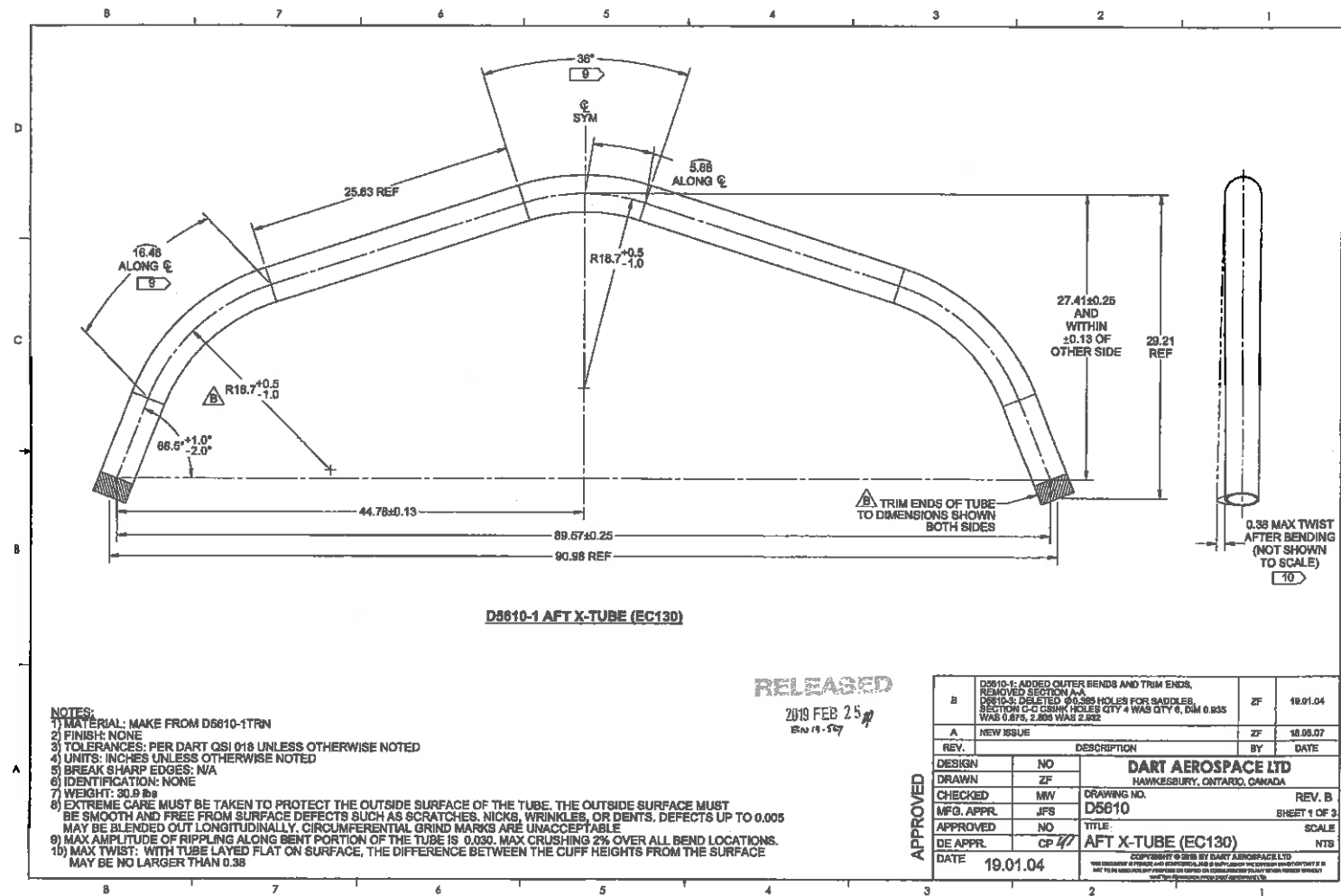
Specifications could not be found.

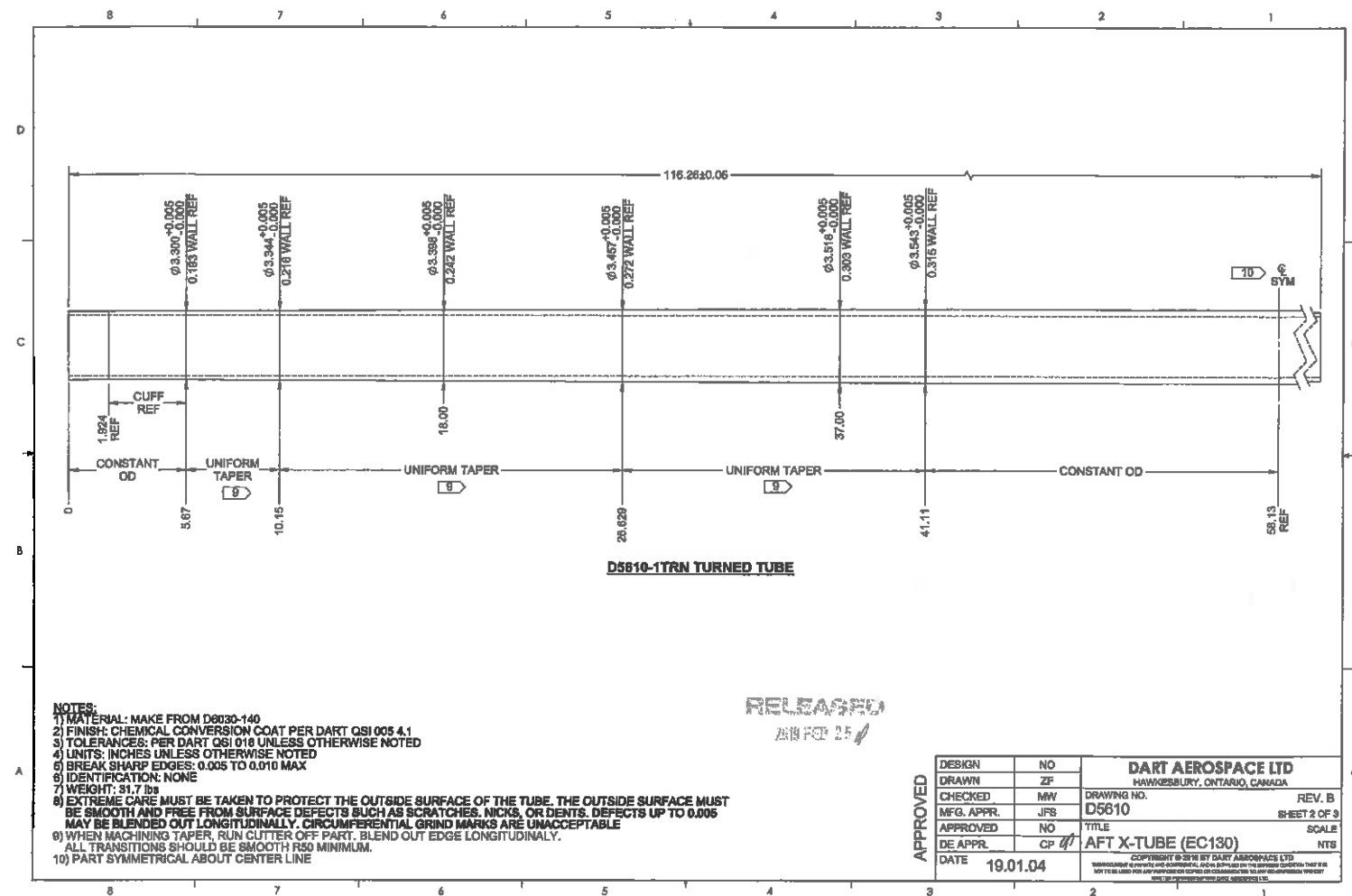
DAS
66
9-89

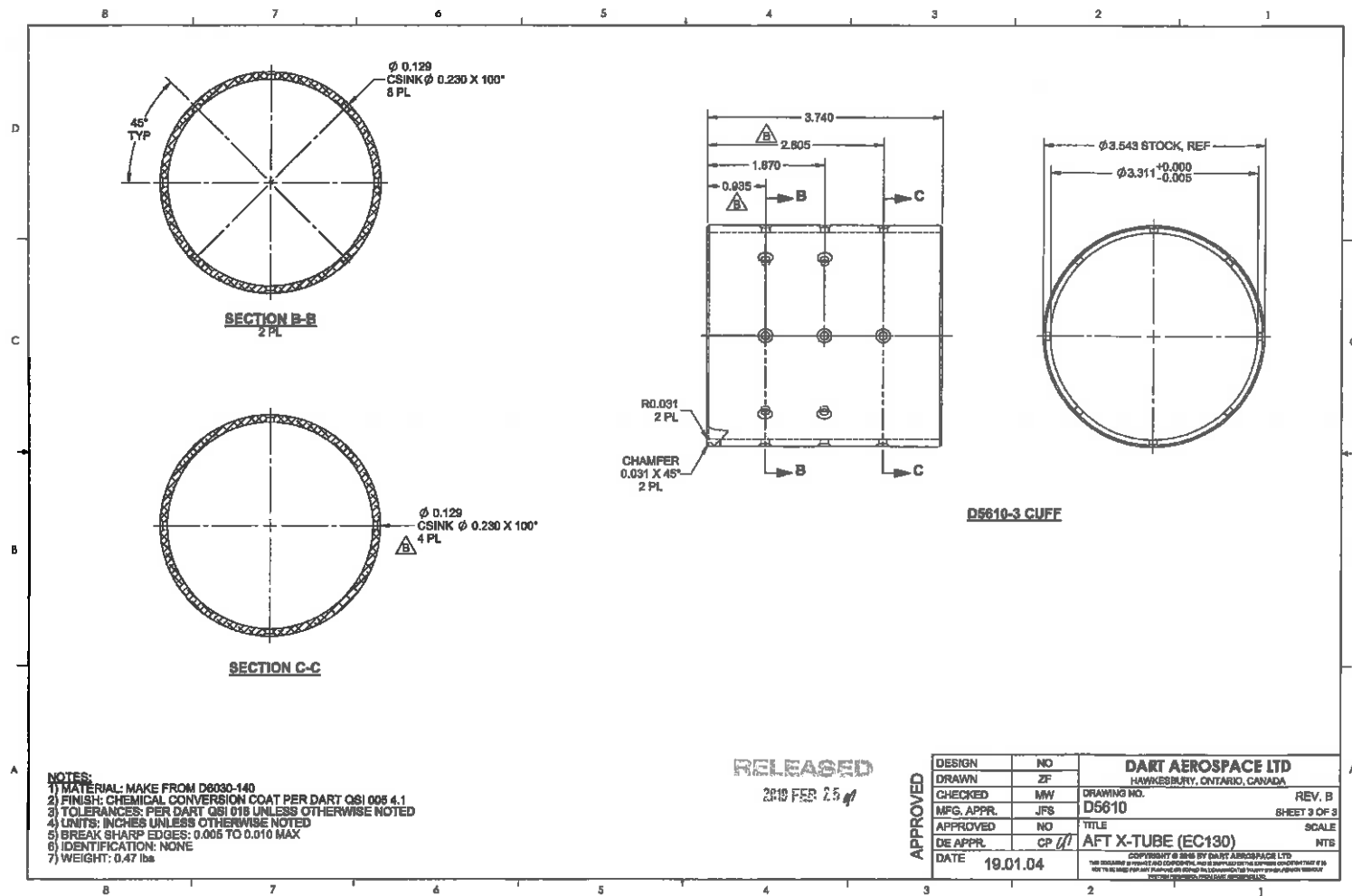
146 - OS NDT KA 2019-06-07
147 - Red
148 - QEB

Plex 3/13/19 2:26 PM dart.lacelle.linda

191954







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DART AEROSPACE LTD		Work Order: 1911754
Description: Crosstube Assembly		Part Number: 05610-1-TRN
Inspection Dwg: B	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

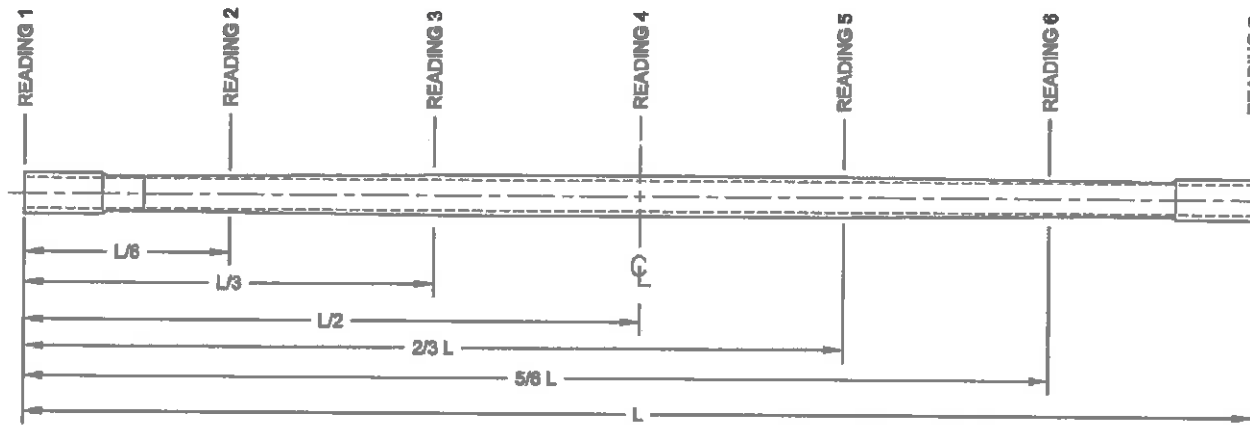
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	-	→ 3.554	✓		CNC-OS	
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
SIDE B	→ 3.336		✓		CNC-OS	
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
			✓			
	±/- 0.030	116.25	✓		Tape	

Acceptable
4/14/1

③

DART AEROSPACE LTD		Work Order: 191954
Description: Crosstube Assembly		Part Number: 05610-1 TRN
Inspection Dwg: 8	Rev: 3	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.206	.200	.191	.196	.015	± 0.030
READING 2 L= 19.38	.265	.262	.240	.241	.025	
READING 3 L= 38.75	.324	.320	.301	.305	.023	
READING 4 L= 58.13	.324	.321	.317	.322	.007	
READING 5 L= 77.51	.316	.320	.314	.310	.010	
READING 6 L= 96.88	.251	.258	.252	.249	.009	
READING 7 L= 116.26	.195	.197	.193	.194	.004	

Calibration Result

Actual Block Thickness: 100-400

Sitescan 250 Measured Thickness: 100-400

Measured by: DAS 66	Audited by: DAS 67	Preliminary Approval:
Date: 2019-03-29	Date: 19-04-01	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	
C	12.06.01	Wall thickness form added	KJ	

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____		DISPOSITION			DEPARTMENT/PROCESS			
Part No. <u>D560-1 TRN</u>		Rework ☒	Scrap ☐	Use-as-is ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
					Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
					Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QSI042) <u>NO 19.05.14</u>		
Description Work Order Deviation		Disposition						
<u>Corrosion pitting and scratches</u>		<u>Grind to remove pitting. Measure wall thickness and diameters after grinding and polish. See engineering for further disposition</u>						
Root Cause		Lead hand / Supervisor						
Operator ☐		QC / QA Coordinator <u>68</u>						
Manufacturing Process ☐		<u>9-88</u>						
Equip/Tooling ☐		JUL 31 2019						
Handling/Preservation ☐								
Material ☐								
Product Improvement ☐								
Process Improvement ☐								
Human Factors ☐								
Other/Details:								
Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐		
Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐		
Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐		
Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐		
Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐		
Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐		
Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐				



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PURCHASE ORDER POHB043652



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043652
PO Date: 6/6/19
Due Date: 6/6/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191954	D5610- 1TRN	EC130 Aft Crosstube Turning Detail : Various STC's ISSUE P/O:	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
2	185902	D412- 664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	185904			Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	185905			Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							3	0	3		\$358.50

3	185904	D412- 664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00
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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	185905	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00
5	195364	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	195366			Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
6	195366	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00



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PURCHASE ORDER POHB043652



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	195393	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	195394			Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00

8		D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00
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PURCHASE ORDER

POHB043652



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	195391	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	195392	1 X	JUN 07 2019	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:								2	0	2	\$239.00

Grand Total: \$1,195.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/7/19 3:55 PM dart.belanger.natasha



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PURCHASE ORDER
POHB043652



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043652
PO Date: 6/6/19
Due Date: 6/6/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

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2	185902	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
3	185904	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
4	185905	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	195364	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
6	195366	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
7	195393	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50



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POHB043652



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	195394	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
9	195391	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
10	195392	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Grand Total:											\$1,195.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043652



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/7/19 1:49 PM Dart.Guerin.Kimberley



Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWG40659	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB043652
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED	Sequence: 1
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Work Required:

CARRY OUT NDT ON 10 CROSSTUBES AS PER POHB043652

2 FWD CROSSTUBES , P/N# D206-667-107BL , J/S# 195391 , 195392

2 AFT CROSSTUBES , P/N# D206-667-207BL , J/S# 195393 , 195394

2 AFT CROSSTUBES , P/N# D212-664-201 , J/S# 195364 , 195366

3 AFT CROSSTUBES (412 STAINLESS STEEL) , P/N# D412-664-403 , J/S# 185902 , 185904 , 185905

1 EC130 AFT CROSSTUBE , P/N# D5610-1TRN , J/S# 191954

Action Taken:		Date:	Initial/Stamp:			
LPI C/O IAW ASTM E-1417M-16 NO CRACK OR CORROSION FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142		RECEIVED JUN 07 2019 DART AEROSPACE LTD. JUN 06 2019	 			
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		JUN 06 2019

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: <u>191954</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>DS60-1TRN</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation				Disposition			
Corrosion pitting exceeds allowables				Scrap			
Root Cause		Completed By					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Lead hand / Supervisor					
		QC / QA Coordinator					
		DAS 68					
		JUL 9 89 2019					
		Positioned Wrong					
		Outside Tolerance					
		Drawing					
		Finish					
		Part Lost/Missing					
		Misread					
		Power Loss/Surge					
		Folio/Program					
		Grain Direction					
		Weld					
		Wrong Stock Pulled					
		Out of Sequence					
		Off-set/Set-up					
		Fault Category					
		Contamination					
		Misaligned/off center					
		BOM/Route					
		Broken/Damage/Defect					
		Incomplete/Unclear Instructions					
		Drill Holes					
		Fit/Function					
		Pressure/Forced					
		Bending					
		Crushing					
		Cracks					
		Crimp/Kink/Ripple/Wave/Twist					
		Marks/Chatter					
		Mislabeled					
		Other/Details:					